		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
		OA Closed:	Date:	

							_				да сюзса.	Dute.	
Work Ord	er.					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
						Rework]		Skid-tube	Crosstube] 	Water Jet	Engineering Quality
Part I	No.					Scrap	-		Machining	Small Fab	_	d. Eng. Coor.	-
						Use-as-is	4	Thern	noforming	Finishing	Rec/Stor	re/Packaging	Other
NCR I	No.					Work Order Update	ا ل		Large Fab	Composite]	Supplier	ا لــا
Daret		T	Τ	<u> </u>	Doscri	ption of work order updaté	Т	Initial	۸۵	tion	Sign &		1
Root		Data	Ston	Ott		or Non-conformance		nief Eng		ription	Date	Verification	QC Inspector
Cause		Date	Step	Qty		or Non-comormance	10	ilei ciig	Desc	приоп	Date	Vernication	Qe mspector
Doc/Data	\vdash												
Equip/Tooling	\vdash												
Operator	-												
Material	┝	ļ											
Setup	<u> </u>												
Other	<u> </u>												
Process		-											
Supplier	<u> </u>												
Training	<u> </u>												
Unapproved			<u> </u>	<u> </u>	<u> </u>			TCATE	CORY				
<u> </u>							-AUI	T CATE	GURY				<u> </u>
Landi	ng (7				General	<u>.</u>	Grain		Γ	Ovalized		Pressure/Forced
	<u> </u>	Bending				Bend	\vdash	4		· -	-	.	Temperature/Cure
		Centre No	ot Concer	ntric to	^{O/S} -	BOM/Route	-	Hardwa		ļ	Over/Under	· -	Weld
	<u> </u>	Cracks			-	Broken/Damaged	\vdash	4 '	ion Incomplete	". , · · <u> </u>	Part Incorre		┥
	<u> </u>	Crushed/	Crimped.		<u> </u>	Burrs	\vdash	4	ions Incomplete/	Unclear	Part Lost/M	-	Wrong Stock Pulled
	_	Cuffs			<u> </u>	Contamination	\vdash	Mainte		-	Part Moved		
	<u> </u>	Heat Trea			ļ	Countersink	\vdash	Mislabe		<u> </u>	Positioned V		704
	<u> </u>	Inspectio	,	Tube	 	Cut Too Short	<u> </u>	Misrea	d .		Power Loss/	Surge	Other
	<u> </u>	Ripples in			<u> </u>	Drill Holes	-	Offset					
	<u></u>	Torque W			n	Drawing	\vdash	Out of Calibration					
	<u></u>	Turning S				Finish		Out of Sequence			-		
Wave/Twist in Tube Folio			_L_	Outside	Dimensions								

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Work Ord January-25-13				*962	28*						Page 2	
Item ID:	D3067-1			Accept	*N900	040	100)* s	etup Star Sto	1/1	S1*	
Item Name: Start Date: Required Date Reference:	End Plate 1/25/13 : 2/15/13	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:				'N	S2*	
Approvals:		an:	Date:	Tooling: SPC (Y/N):		ate:		R	Run Stai Sto		R1* R2*	
Sequence ID/ Work Center I 130 *130* Brake NC Brake NC	D	Operation Description NC BRAKE Memo Bend as per l	Dwg D3067	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.	10
* 14 0 *140 * QC Quality Control		QC5- Inspect part comple Memo	eteness to step on W/O	0.00 Smf 0.00 13 S. 9				40, can	7	. <u></u>	- 	
150 *150* Packaging		Identify as per dwg & Sto	ock Location:_WM	0.00				40	4		K.	2

*** STOCK IN STEP CELL***

Packaging

		DQA:	Date:	<u> </u>
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

										QA Closed:	Date:	
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part No				Rework Scrap Use-as-is Work Order Update	Th	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root	Root Desc			Descri	ption of work order update	Initia	1	Ac1	tion	Sign &		
Cause	Dat	e Step	Qty	i .	or Non-conformance	Chief E	ŀ		ription	Date	Verification	QC Inspector
Doc/Data			1									
Equip/Tooling											ν.	
Operator												
Material												·
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Other .												}
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Training												
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Landi	ng Gear			_	General	_			<u></u>	٦		۱ ا
	Bendi	_			Bend	Gra	in			Ovalized		Pressure/Forced
		Not Conce	entric to	o/s	BOM/Route	├ ──	dware			Over/Under	 	Temperature/Cure
	Crack			ļ	Broken/Damaged	\vdash		Incomplete	-	Part Incorre		Weld
		ed/Crimped	l <u>.</u>	<u> </u>	Burrs	\vdash		s Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination		intenai	ıce		Part Moved		
	Heat			-	Countersink	${f oxdot}$	Mislabeled			Positioned V		7
		tion Strip ii	1 Tube	<u> </u>	Cut Too Short		Misread			Power Loss/	Surge	Other
		s in Bend		<u> </u>	Drill Holes	Offs						
		e Waves in		n	Drawing	├ ──	of Calib					
		g Sequence		<u> </u>	Finish	Out of Sequence Outside Dimensions						
	Wave	/Twist in Tu	be	1	Folio	Outs	side Dir	nensions				

Work Order ID 96228 *96228* Page 3 January-25-13 9:18:48 AM Item ID: D3067-1 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: End Plate *40* **Start Qty: 40.00 Start Date:** 1/25/13 **Cust Item ID:** Required Date: 2/15/13 Req'd Qty: 40.00 **Customer:** Reference: Run Process Plan: Date: **Tooling:** Date: Approvals: Stop QC: Date:_____ SPC (Y/N): Date: Sequence ID/ Tool ID Tool # Plan Reject Reject Set Up/ Accept Operation Insp. **Work Center ID** Description Run Hours Code Qty Qty Number Stamp QC21- Final Inspection - Work Order Release 0.00 160 *160* 0.00 Memo

Quality Control

13-9-14

											DQA:	Date	≘: _	
NCR:	Yes	/ No				WORK ORDER NON-C	10:	NFORM	//ANCE / UPDA	TE				
											QA Closed:	Date	e:	
March Ord						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Work Ord	er: _					Rework			Skid-tube (Crosstube	Water Jet			Engineering
Part (No.					Scrap			⊢ —	Small Fab	Pro	d. Eng. Coor.	\dashv	Quality
Falli	۱U					Use-as-is			noforming	Finishing		e/Packaging	\dashv	Other
NCR I	No.					Work Order Update			~ - -	Composite	1100,010	Supplier	7	
	_						'		·	'				
Root					Descri	ption of work order update		nitial	Action)	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Descript	ion	Date	Verification	4	QC inspector
Doc/Data	Ш													
Equip/Tooling	Ш		1				İ			i				
Operator	Ш													
Material	Ш												1	
Setup	Н											<u> </u>		
Other	Ш													
Process	Н												Ì	
Supplier	Ш											1		
Training	Н													
Unapproved			<u> </u>	<u> </u>	<u> </u>	-	<u></u>	T 64 TE				<u> </u>		
ļ							AUL	T CATE	GURY					
Landi	$\overline{}$				Г	General	$\overline{}$	1:-			Ovalized	Г	٦.	Pressure/Forced
	$\boldsymbol{\vdash}$	Bending			~ 	Bend BOAA/Bauta	\vdash	Grain		-	4	talaransa	_	Temperature/Cure
	Centre Not Concentric to O/S BOM/Route Hardware Cracks Broken/Damaged Inspection Incomplete						Over/Under Part Incorre	-		Weld				
						Wrong Stock Pulled								
	-		crimped.		-	Burrs	-	4	•	lear	Part Moved	issirig		wrong stock rulled
	1 1	Cuffs	Contamination Maintenance					Trait inioned						

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Picklist Print

January-25-13 9:18:48 AM

Work Order ID:

96228

Parent Item:

D3067-1

Parent Item Name:

End Plate

Start Date: 1/25/13

Required Date: 2/15/13

Page 1

Start Qty: 40.00

Required Qty: 40.00

Comments:

ΚJ

IPP: 03.01.21 Remove step 6 (Deburr)
IPP Rev:B Now on Water jet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063 5052-H32 .063 Sheet		Purchased	No			100	sf	81.3053	0.0625	2.63158		13.0	<u> </u>
				Location		Loc Qty	<u>Lo</u>	c Code		- 4 0			
				MAT022		81.305264			<u>1256</u>	117			
				1143	322	25.705264							
				1206	503	24.5							
				1219	001	31.1							

		•	DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
	•		QA Closed:	Date:	

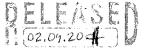
								····	QA Closea.		
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N				4	Rework Scrap	Scrap Machining Small Fab		Crosstube Small Fab	Water Jet Prod. Eng. Coor.		Engineering Quality Other
NCR N	0	- -			Use-as-is Work Order Update	Inei	Thermoforming Finishing Rec/Store/Packaging Supplier				
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desci	ription	Date	Verification	QC Inspector
Doc/Data											
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Operator											
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Setup											
Other											
Process							İ				
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Unapproved						<u> </u>					<u> </u>
· · · · · · · · · · · · · · · · ·					F.	AULT CAT	EGORY				
Landin	g Gear				General			· -	3		-
	Bending			L	Bend	Grain		ļ	Ovalized	<u> </u>	Pressure/Forced
1	Centre No	ot Concer	ntric to (o/s	BOM/Route	Hardv			Over/Under	 	Temperature/Cure
	Cracks				Broken/Damaged	\mathbf{H}	ction Incomplete	<u> </u>	Part Incorre)	Weld
	Crushed/	Crimped.		<u> </u>	Burrs	\vdash	ctions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
_	Cuffs	-		<u></u>	Contamination		tenance	ļ	Part Moved		
Ĺ	Heat Trea				Countersink	Misla			Positioned V		
	Inspection		Tube	L	Cut Too Short	\vdash	Misread			'Surge	Other
	Ripples in			<u></u>	Drill Holes	Offset					
	Torque W			n	Drawing	Out of Calibration					
<u> </u>	Turning S				Finish	Out of Sequence					
- 1	Wave/Tw	ist in Tub	e e	1	Folio	Outside Dimensions					

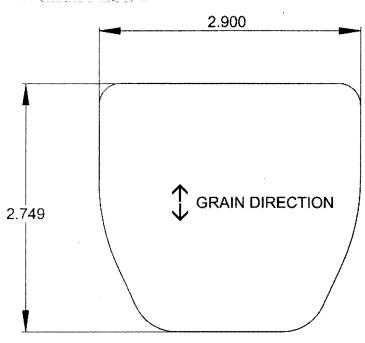
DART AEROSPACE LTD	Work Order:	96228
Description: End Plate	Part Number:	D3067-1
Inspection Dwg: D3067 Rev: A		Page 1 of 1

	FI	RST ARTICLI	E INSPEC	TION CH	IECKLIST		
		X First A	rticle [Pro	totype	٠	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	mments
2.900	+/-0.010	2.900			V	TK	401
2.749	+/-0.010	2.745	1		V .		
							<u>.</u> .
Measured by:	MN	Audited by	: 27		Prototype App	roval	N/A
Date:	M/W/ 13.05.05	Date	- 32	7	· iototype App	Date:	N/A
Rev Date A 03.10.07	Change New Issue				R	evised by	Approved

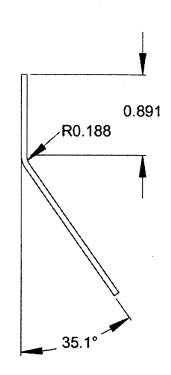


DESIG	· a	DRAWN BY	DART AEROS HAWKESBURY, ON	-
CHECK	界	APPROYED	D3067	REV. A SHEET 1 OF 1
DATE	02.0	9.11	END PLATE	SCALE 1:1
Α	0	2.09.11	NEW ISSUE	





D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

D3067-1 END PLATE

1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063) ALUMINUM SHEET, 0.063 THICK

3) FINISH: NONE

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 5) ALL DIMENSIONS ARE IN INCHES

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